

Work Order ID 71156-2 split 2.

Monday, July 11, 2011 11:07:58 AM



DUPLICATE

Page 1

Item ID: D4151-043

Accept



Setup Start



Revision ID:

Item Name: Basket Fwd Hardpoint Assembly, Upper

Stop



Start Date: 6/23/2011 Start Qty: 4.00 -4



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *P*

Date: 11-07-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4151

C

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

SP 11/09/08 (4)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/02/08

(74)

120

Identify as per dwg & Stock Location: *ST 134*

0.00



Packaging

Memo

0.00

Packaging

4x SP 11-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 71156

Page 2

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Stop



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Date:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

139

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/03

H 1140-3

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Picklist Print

Monday, July 11, 2011 11:08:04 AM

Page 1

Work Order ID: 71156

Parent Item: D4151-043

Parent Item Name: Basket Fwd Hardpoint Assembly, Upper




Start Date: 6/23/2011

Required Date: 7/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM
11.01.21 as per dwg revC DD verf:JLM IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
* D4151-3  Upper Hardpoint Plate		Manufactured	No			100	Each	10.0000	2	8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST134				10					
					70755			10					
* D4151-7  Fwd Eyebolt Receiver (Upper)		Manufactured	No			100	Each	1.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST134				1					
					61233			1					
* AN4C13A  BOLT		Purchased	No			100	Each	23.0000	2	8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST357				23					
					117793			23					

Handwritten notes:
B73050
B71155 (1x)
B73049 (3x)
M118451

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Picklist Print

Monday, July 11, 2011 11:08:04 AM

Page 2

Work Order ID: 71156



Parent Item: D4151-043



Parent Item Name: Basket Fwd Hardpoint Assembly, Upper

Start Date: 6/23/2011

Required Date: 7/11/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

100

Each

770.0000

2

8



Nut



GP 11/09/28

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

730

117601

230

117793

500

8

NAS1149C0432R

Purchased

No

100

Each

5,032.000

4

16



Washer



GP 11/09/28

Location

Loc Qty

Loc Code

ST297

5032

116900

414

117291

4618

16

Dart Aerospace Ltd

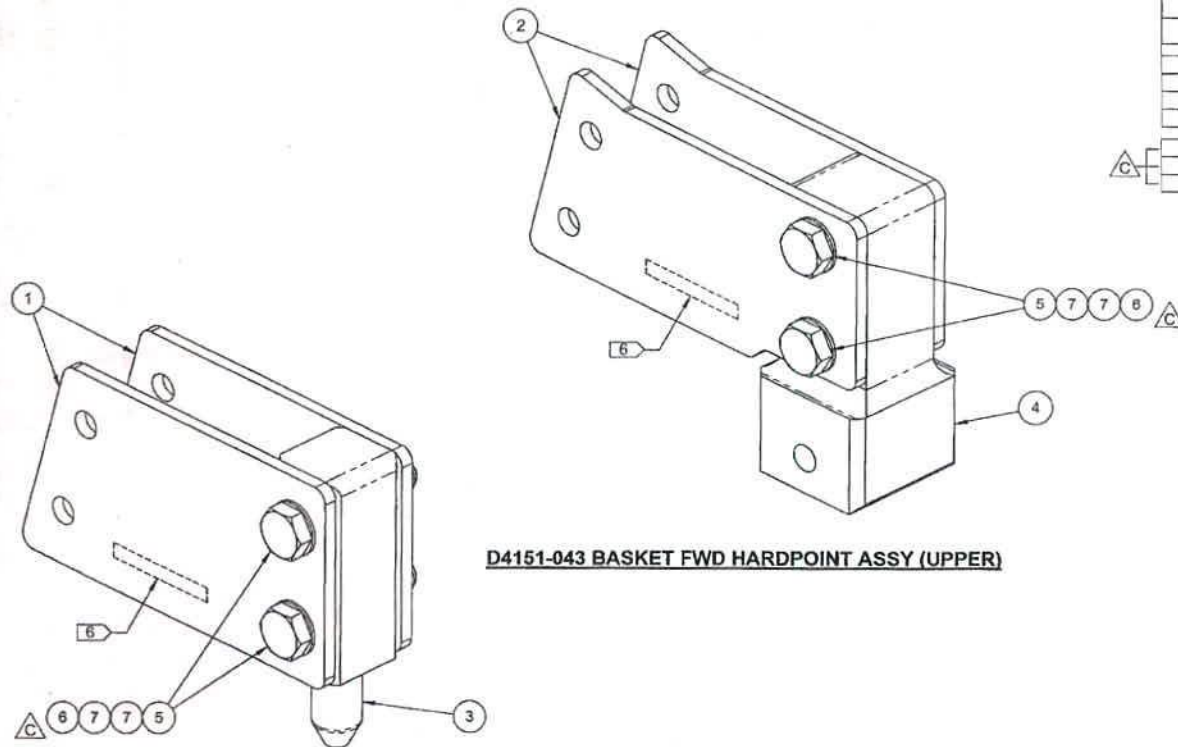
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D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)

D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71156

D411-074

RELEASED
2011-01-08
JRP

C	AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C6-3, B4-3); 1.83 WAS 1.75 (C1-2), 2.24 WAS 2.78 (B3-3) AND 1.82 WAS 1.80 (C1-3) TO PRESERVE 1.5SD. REASON: SEE D407-7197 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20915-AM20 (ZN C3-1, D3-1 & B6-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-D350-807-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		

DART AEROSPACE LTD
HAWKESSBURY, ONTARIO, CANADA

DRAWING NO. D4151
REV. C
SHEET 1 OF 3
TITLE BASKET FWD HARDPOINT
SCALE NTS

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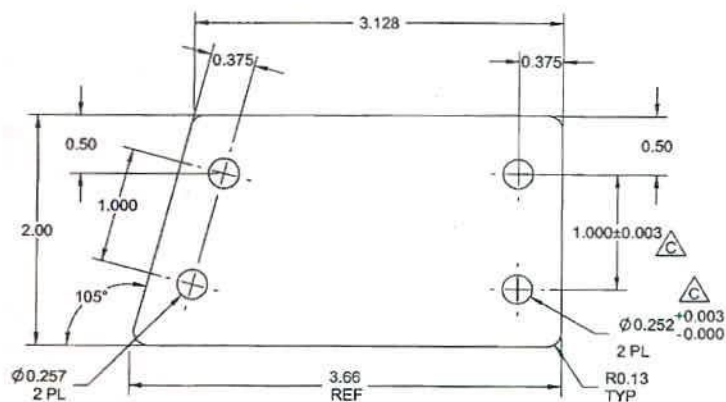
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

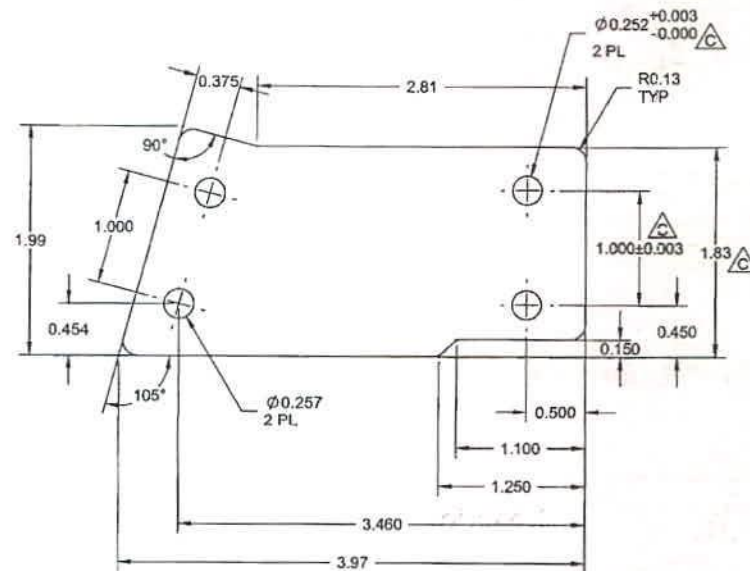
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NOTE: Date & initial all entries



D4151-1 LOWER HARDPOINT PLATE



D4151-3 UPPER HARDPOINT PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:
 - D4151-1 = 0.24 lbs
 - D4151-3 = 0.23 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4151	SHEET 2 OF 3
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DE APPR.		BASKET FWD HARDPOINT	
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2011-01-08
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71156

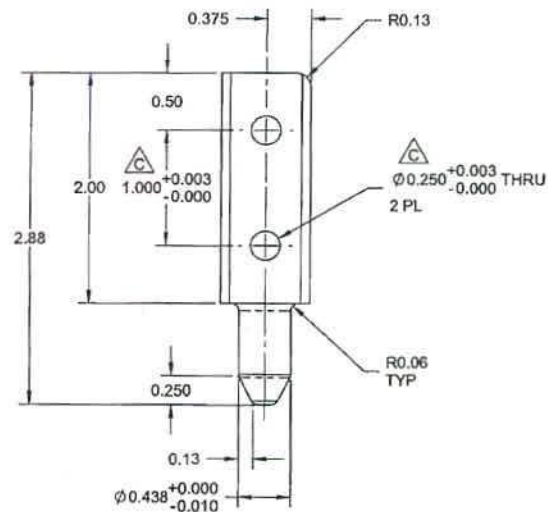
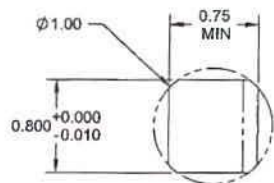
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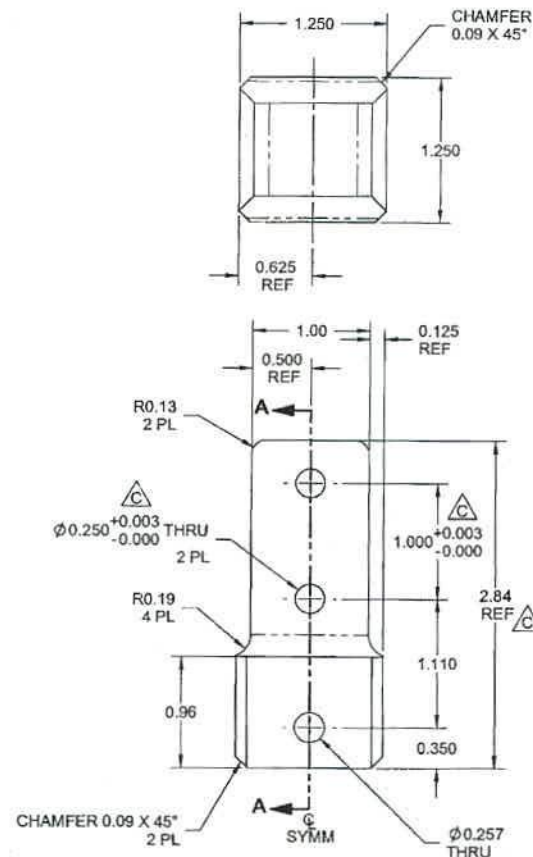
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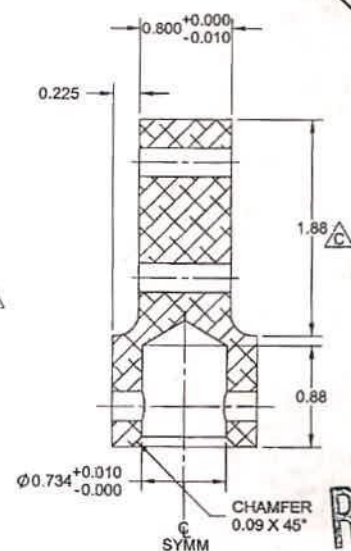
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D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

NOTES:

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

711 5C

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4151	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
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R 2011-01-13
RELEASED

W/O:		WORK ORDER CHANGES					
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